

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029278**Date Inspected:** 19-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** jobsite**CWI Name:** Tony Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Quality Assurance Inspector (QAI) Matthew Daggett was at the American Bridge/Fluor (ABF) job site at the San Francisco/Oakland Bay Bridge in California between the times noted above in order to perform support tasks in the office, and to monitor Quality Control functions and the in process work being performed by ABF personnel:

Deck Access Hole 12E-PP116.5-E2 Exterior

This QAI observed the welder Mike Jiminez (ID#4671) performing welding operations on the above mentioned weld joint utilizing the Shield Metal Arc Welding process.

The welder spent the shift depositing the root passes and fill passes with approximately 50% being completed at the end of the shift. The QC Inspector Tony Sherwood was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D15-1040-C1 Rev 0 and supporting Procedure Qualification Record (PQR). Prior to and during the welding at this location the QC inspector Tony Sherwood monitored the preheat temperature using a Raytek non-contact Thermometer, and found it to be sufficient and compliant to the above-mentioned WPS. Using a Tempil Stick, (temperature indicating crayon) the pre-heat was then verified by this QA inspector to be greater than 150F. Utilizing a Fluke 337 Clamp Meter, the parameters were verified by this QAI to be in compliance with the WPS.

Deck Access Hole 12W-PP116.5-W2 Interior

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This Quality Assurance Inspector observed welder Chris Bruce (ID #8901) back gouging and grinding the interior of the above-mentioned weld joint. Mr. Bruce was back gouging to sound metal than using a disc grinder to bring the interior surfaces of the weld joint to a bright clean metal condition. This QAI noted at the end of the shift Mr. Bruce was approximately 90% complete back gouging and grinding.

Lifting Lug Hole 11 East

This QAI observed the welder Wai Kit Lai performing welding operations on the above mentioned weld joint utilizing the Shield Metal Arc Welding process.

The welder spent the shift depositing the root passes and fill passes with approximately 100% being completed at the end of the shift. QC inspector Tony Sherwood was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D15-1030-1 Rev 0 and supporting Procedure Qualification Record (PQR). Prior to and during the welding at this location the QC inspector Tony Sherwood monitored the preheat temperature using a Raytek non-contact Thermometer, and found it to be sufficient and compliant to the above-mentioned WPS. Using a Tempil Stick, (temperature indicating crayon) the pre-heat was then verified by this QA inspector to be greater than 150F. Utilizing a Fluke 337 Clamp Meter, the parameters were verified by this QAI to be in compliance with the WPS.

Lifting Lug Hole 12 East

This QAI observed the welder Wai Kit Lai performing welding operations on the above mentioned weld joint utilizing the Shield Metal Arc Welding process.

The welder spent the shift depositing the root passes and fill passes with approximately 100% being completed at the end of the shift. QC inspector Tony Sherwood was noted to be present in order to monitor the progress and ensure the welding was within the established Welding Procedure Specification (WPS) noted as ABF-WPS-D15-1030-1 Rev 0 and supporting Procedure Qualification Record (PQR). Prior to and during the welding at this location the QC inspector Tony Sherwood monitored the preheat temperature using a Raytek non-contact Thermometer, and found it to be sufficient and compliant to the above-mentioned WPS. Using a Tempil Stick, (temperature indicating crayon) the pre-heat was then verified by this QA inspector to be greater than 150F. Utilizing a Fluke 337 Clamp Meter, the parameters were verified by this QAI to be in compliance with the WPS.

Summary of Conversations:

See body of report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas 916-764-6027, who represents the Office of Structural Materials for

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your project.

Inspected By: Daggett,Matt

Quality Assurance Inspector

Reviewed By: Reyes,Danny

QA Reviewer